

Date: Tuesday, 7/1/2008 2:35:06 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	40198					
Estimate Number	10533					
P.O. Number				Part Number	D2573	
This Issue	7/1/2008		S.O. No.	Drawing Number	D2573 REV E	
Prsht Rev.	NC			Project Number	N/A	
First Issue	/ /		Type	Drawing Revision	E	
Previous Run	39808			Material		
Written By				Due Date	7/23/2008	
Checked & Approved By	9/08/07, 01			Qty:	10	
Comment	Est: 1 As Per RevE 06-01-27 JLM			Um:	Um: Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: 834875	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: 90198 Double check by:	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:35:06 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 40198

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK



88 08/08/23

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M 08-08-25

X10

7.0 POWDER COATING POWDER COATING



M 108523

10X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:40

OVEN TEMPERATURE: 320°

FINISH TIME: 12:10

M 08/08/23

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-08-25

X10

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 433

10X

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/08/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/08/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40198
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.439	.440	.440	.441		
B	1.745	1.755		1.750	1.750	1.750	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.506		
D	1.745	1.755		1.750	1.750	1.750	1.749		
E	7.990	8.010		8.005	8.000	8.000	8.000		
F	0.490	0.510		.510	.501	.505	.500		
G	0.257	0.262		.258	.258	.258	.260		
H	0.375	0.380		.377	.377	.377	.378		
I	0.490	0.510		.504	.510	.510	.510		
J	1.174	1.184		1.179	1.179	1.179	1.178		
K	0.558	0.578		.568	.576	.577	.578		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.502	2.502	2.506		
O	4.119	4.129		4.125	4.125	4.125	4.125		
P	0.115	0.135		.126	.126	.126	.127		
Q	0.115	0.135		.130	.130	.130	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.125	.124	.125	.124		
T	0.178	0.198		R.188	R.188	R.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.228		
V	0.230	0.250		.239	.240	.239	.240		
W	0.115	0.135		.126	.120	.120	.125		
X	0.308	0.313		.312	.311	.311	.311		
Y	0.760	0.765		.761	.760	.761	.761		
Z	0.352	0.372		.368	.369	.369	.369		
AA	0.470	0.530		R.500	R.500	R.500	.500		
AB	0.615	0.635		.630	.629	.626	.625		
AC	0.053	0.073		.063	0.063	0.063	.063		
AD	0.240	0.260		.252	.251	.251	.247		
AE	1.500	1.520		1.512	1.513	1.513	1.514		
AF	0.115	0.135		.135	.135	.135	.128		
AG	0.240	0.280		.273	.273	.273	.265		
AH	0.240	0.260		.251	.251	.251	.248		
AI	2.000	2.020		2.002	2.002	2.003	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: J.F. / amf  
Date: 08/08/20

Audited by: 89  
Date: 08/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD				Work Order:	40198
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.504	.502	.503	.502		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.501	.500	.501	.501		
J	1.174	1.184		1.179	1.179	1.180	1.180		
K	0.558	0.578		.570	.569	.570	.570		
L	1.174	1.184		1.179	1.179	1.180	1.179		
M	1.365	1.375		1.370	1.370	1.369	1.369		
N	2.495	2.505		2.500	2.506	2.506	2.500		
O	4.119	4.129		4.124	4.124	4.125	4.124		
P	0.115	0.135		.127	.127	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.251	.252		
S	0.115	0.135		.125	.121	.122	.123		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.229	3.229	3.229	3.229		
V	0.230	0.250		.241	.246	.240	.239		
W	0.115	0.135		.127	.121	.128	.128		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.766	.760	.766	.760		
Z	0.352	0.372		.367	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.246	.247	.248		
AE	1.500	1.520		1.512	1.512	1.513	1.513		
AF	0.115	0.135		.122	.122	.123	.123		
AG	0.240	0.280		.261	.266	.265	.265		
AH	0.240	0.260		.249	.249	.249	.249		
AI	2.000	2.020		2.001	2.000	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>GML</i>	Audited by:	<i>SS</i>
Date:	08/08/22	Date:	08/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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E	05.12.05	Added dimension AJ	KJ/JLM <i>SS</i>	<i>JLM</i>

DART AEROSPACE LTD				Work Order: 40198	
Description: Saddle, Aft Outboard				Part Number: D2573	
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

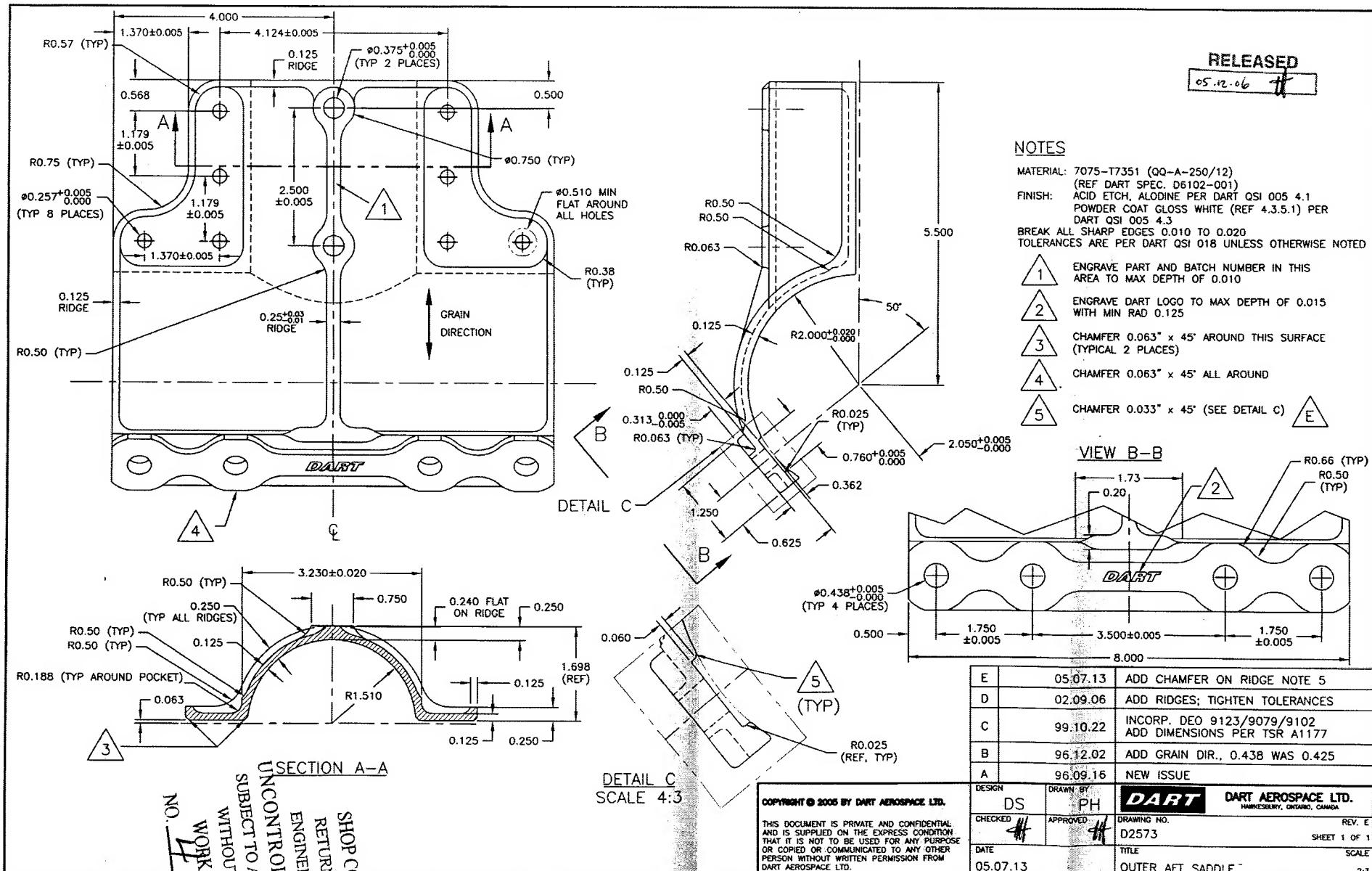
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B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.506	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.006	8.006				
F	0.490	0.510		.501	.503				
G	0.257	0.262		.266	.260				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.502	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.569	.567				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.376	1.370				
N	2.495	2.505		2.500	2.506				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.124	.124				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.252	.251				
S	0.115	0.135		.121	.124				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.229	3.229				
V	0.230	0.250		.246	.239				
W	0.115	0.135		.127	.128				
X	0.308	0.313		.311	.311				
Y	0.760	0.765		.766	.766				
Z	0.352	0.372		.364	.365				
AA	0.470	0.530		.506	.500				
AB	0.615	0.635		.630	.628				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.246	.245				
AE	1.500	1.520		1.513	1.512				
AF	0.115	0.135		.125	.124				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.249	.247				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				

Accept/Reject

Measured by:	<i>Amf</i>	Audited by:	<i>88</i>
Date:	<i>08/08/22</i>	Date:	<i>08/08/23</i>

Rev	Date	Change	Revised by	Approved
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D	05.05.05	Added dimension AI	KJ/RF	
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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.15	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAMILTON, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. REV. E
		D2573 SHEET 1 OF 1
DATE		TITLE SCALE
05.07.13		OUTER AFT SADDLE